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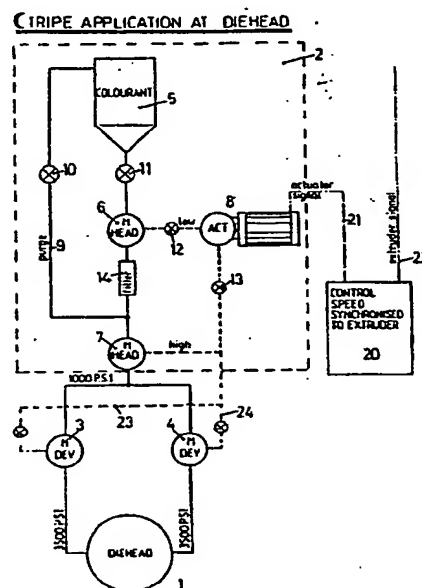
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54 Apparatus for and method of modifying an extruded material.

(57) Apparatus for colouring an extruded plastics material comprises metering devices (2 and 3) for feeding colourant to an extruded plastics material being fed to a diehead (1). The colourant is supplied at the diehead or between the diehead and the outlet from the extruder. The metering devices may be diaphragm pumps, gear pumps or reciprocating piston pumps. This arrangement requires fewer extruders and obviates problems resulting from balancing of different plastics material flows.



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APPARATUS FOR AND METHOD OF MODIFYING
AN EXTRUDED MATERIAL

The present invention relates to apparatus and method for modifying an extruded material. The apparatus and method
5 is particularly, but not exclusively, concerned with colouration, especially the colouration of insulated electrical cable to enable colour coding.

Colour coding of insulated electrical cable and a method of and apparatus for producing it is
10 already known. In this method and apparatus, the basic synthetic plastics material is extruded around the electrical conductor by means of an extruder feeding a diehead. Further subsidiary extruders feed synthetic plastics material of a
15 different colour to that of the basic material to the diehead to produce stripes of that different colour in the basic extruded material. This method and apparatus works well but requires at least one additional extruder and can require
20 considerable monitoring and balancing of the different plastics material flows. Furthermore where more complex arrangements, perhaps involving the production of two or more stripes of different

colours are required, considerable difficulty can be experienced in incorporating the necessary additional extruders.

According to one aspect of the present invention
5 there is provided apparatus for modifying an extruded material comprising a diehead, an extruder for supplying extruded material to the diehead and a metering device for feeding additive to the extruded material to modify the extruded material.

10 According to another aspect of the present invention, there is provided a method of modifying an extruded material including the steps of supplying an extruded material to a diehead and feeding and metering additive to the extruded material to modify the extruded material.

15 The metering device may be a diaphragm pump, a gear pump, a reciprocating piston pump or other suitable device.

In a preferred embodiment, in which insulation is extruded and formed around an electric conductor, one or more stripes of a different colour to the colour of the basic
20 material are formed in the basic material. To this end, the additive is a liquid colourant and is supplied under pressure to the diehead by the or each metering device. A.D.C. driven actuator and associated priming metering pumps (which may also be diaphragm pumps reciprocating piston pumps or
25 gear pumps) boost the pressure on the inlet side of the metering devices to inhibit or prevent reverse flow of colourant through the devices. A single colourant

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source may be provided for two metering devices or respective sources may be provided for different metering devices in the latter case stripes of different colour may be produced by the different devices.

5 Only one metering device or more than two metering devices may be provided as required. Each metering device may have only one additive outlet or more than one if necessary. Advantageously the or each outlet from the or each metering device exits
10 into the plastics flow passage in the die head preferably just upstream of the point at which the material exits from the head.

In order that the invention may be more clearly understood, two embodiments thereof will now be
15 described, by way of example, with reference to the accompanying drawings, in which:-

Figure 1 shows a diagram of apparatus for producing coloured stripes on extruded products,

Figure 2 shows a part of the apparatus of Figure
20 1 but in greater detail, and

Figure 3 shows an alternative to the part of the apparatus shown in Figure 2.

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Figure 4 shows an alternative to the part
of the apparatus shown in Figure 2;

Figure 5 shows an alternative to the apparatus
of Figure 1;

5 Figure 6 shows a modification of the alternative
arrangement of Figure 5;

Figure 7 shows another alternative to the
arrangement of Figure 1; and

10 Figure 8 shows a modification of the alternative
arrangement of Figure 7.

Referring to Figure 1, apparatus for applying two
stripes of the same colour to an extruded product comprises
a diehead 1, a colourant supply circuit indicated generally
by the reference numeral 2 and two diaphragm pumps 3 and 4.
15 The colourant supply circuit 2 comprises a stainless steel
container 5 for low mobility colourant connected to two
metering heads 6 and 7 and a D.C. motor driven actuator 8.
Although in this embodiment, the colourant is low mobility,
it need not necessarily be so. The circuit also comprises
20 a purge line 9 incorporating a valve 10 various other valves
11, 12 and 13 and a filter 14. The metering heads 6 and 7
boost the pressure of the colourant on the inlet side of the
diaphragm pumps 3 and 4. For satisfactory colourant
injection, the pressure on the outlet side of the metering
25 devices must be above a certain minimum in order to inject
colourant into the diehead. The pressure boost is therefore

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necessary in order to reduce the pressure differential across the metering pumps and therefore to prevent or inhibit colourant flow back across the diaphragm pumps. Pressures on the inlet and outlet sides of the diaphragm pumps 3 and 4 may be of the order of 1000 and 3500 p.s.i., respectively. A control unit 20 is provided for synchronising colourant supply to the speed of the extruder (not shown in Figure 1) supplying the diehead 1. For this purpose, control lines 21 and 22 connect the control unit 20 respectively to the actuator 8 and the extruder. Where, as here, the metering devices 3 and 4 are diaphragm pumps, those devices are connected by hydraulic lines 23 and 24 to the actuator 8. Metering heads 6 and 7 may also be diaphragm pumps. In the case of metering devices which are gear pumps (possibly D.C.motor driven) the devices would be connected to the control 20 instead. Such an arrangement is shown in Figures 7 and 8. The gear pumps are referenced 73 and 74 (in Figure 7) 83 and 84 (in Figure 8) and the D.C.motor 700 (in Figure 7) and 800 (in Figure 8). Where the metering devices are reciprocating pumps, the arrangement would be as shown in Figures 5 and 6. The reciprocating pumps are referenced 53 and 54 (in Figure 5) and 63 and 64 (in Figure 6). In the embodiments of Figures 5, 6, 7 and 8 parts equivalent to parts of the Figure 1 embodiment bear the same reference numerals prefixed by the numeral of the

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respective Figure itself. As compared with the Figure 1 embodiment in the embodiments are Figures 5, 6, 7 and 8 two separate lines run from the colourant container. As compared with the embodiments of Figures 5 and 7, in which colourant is supplied at the die head; colourant in the embodiments of Figures 6 and 8 is supplied between diehead and extruder. In this respect the latter two embodiments correspond to the modification of Figure 4 whilst the former two corresponds to the
10 embodiment of Figure 2. With the exception of the diehead and extruder, the apparatus may be constructed as a freestanding assembly comprising a stand on castors enabling it to be moved towards and away from the extruder.

15 The colourant entrance to the diehead 1, is shown in greater detail in Figure 2. Referring to this figure, the diehead itself comprises a longitudinally extending central guide tube 34 in which a core tube 37 is disposed defining a central bore
20 38 through which, in use, a wire to be insulated passes. Concentrically surrounding the guide tube 34 is an outer cylinder body 33. The downstream end 39 of the guide tube 34 is conically tapered and receives a conically shaped point 40 which fits over
25 the downstream end of the core tube 37.

Concentrically surrounding the tapered end 39 and shaped point 40 is the die 41 of the diehead. A passage 42 for plastics material is defined between the die 41 and the end 39 and point 40. This
5 passage 42 communicates with a plastics material passage 43 defined between the cylindrical body 33 and the guide tube 34.

The colourant entrances 36 are let into respective recesses 32 formed in the outer cylindrical body
10 33 of the die. The plastics material extruder (shown in dashed outline 44) comprises an outlet 45 which is connected to the upstream end of the body 33 and which feeds plastics material into the passage 43. As the plastics material moves down
15 the passage 43 into the passage 42, colourant is fed into a passage 59 formed in the surface of a plate 60 which surrounds the die 41. Passage 59 leads to a passage 43 defined between body 33 and guide tube 34. Thus colourant is applied to
20 the surface of the flow thus producing two coloured stripes on this surface at 180° to each other. The end product therefore is an insulated wire with the basic colour of the insulation that of the plastics material fed from the extruder. The colour
25 of the colourant is chosen as desired. Here the

stripes are both the same colour, but stripes differing in colour may be provided by feeding each diaphragm pump 2, 3 with colourant of an appropriate colour.

5 Figure 3 shows an alternative colourant injection arrangement to that illustrated in Figure 2. The diehead is substantially the same as that of Figure 2 (equivalent Figure 3 parts bear the same references as Figure 2 but preceded by the
10 numeral 3) but the colourant entrances are differently formed. Plate 60 is dispensed with, recesses 332 are enlarged and colourant is injected straight from the outlets from the pumps into passage 343. Screws 70 are provided to alter the cross section
15 of the outlet 336 to alter the rate at which colourant is injected. The colourant injection path in Figure 3 therefore differs from that in Figure 2 but the effect is substantially the same two coloured stripes being applied to the plastics mass as it
20 flows through the diehead.

As has already been indicated, Figure 4 shows an alternative to the part of the apparatus shown in Figure 2 in which colourant is introduced between the

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diehead and the extruder rather than at the diehead
as in the arrangement of Figure 2. Both the new
introduction positions, referenced 400, and the
original introduction positions are shown for the
5 purposes of comparison. Parts of the embodiment of
Figure 4 equivalent to those of the embodiments of
Figure 2 bear the same references prefixed by the
numeral 4.

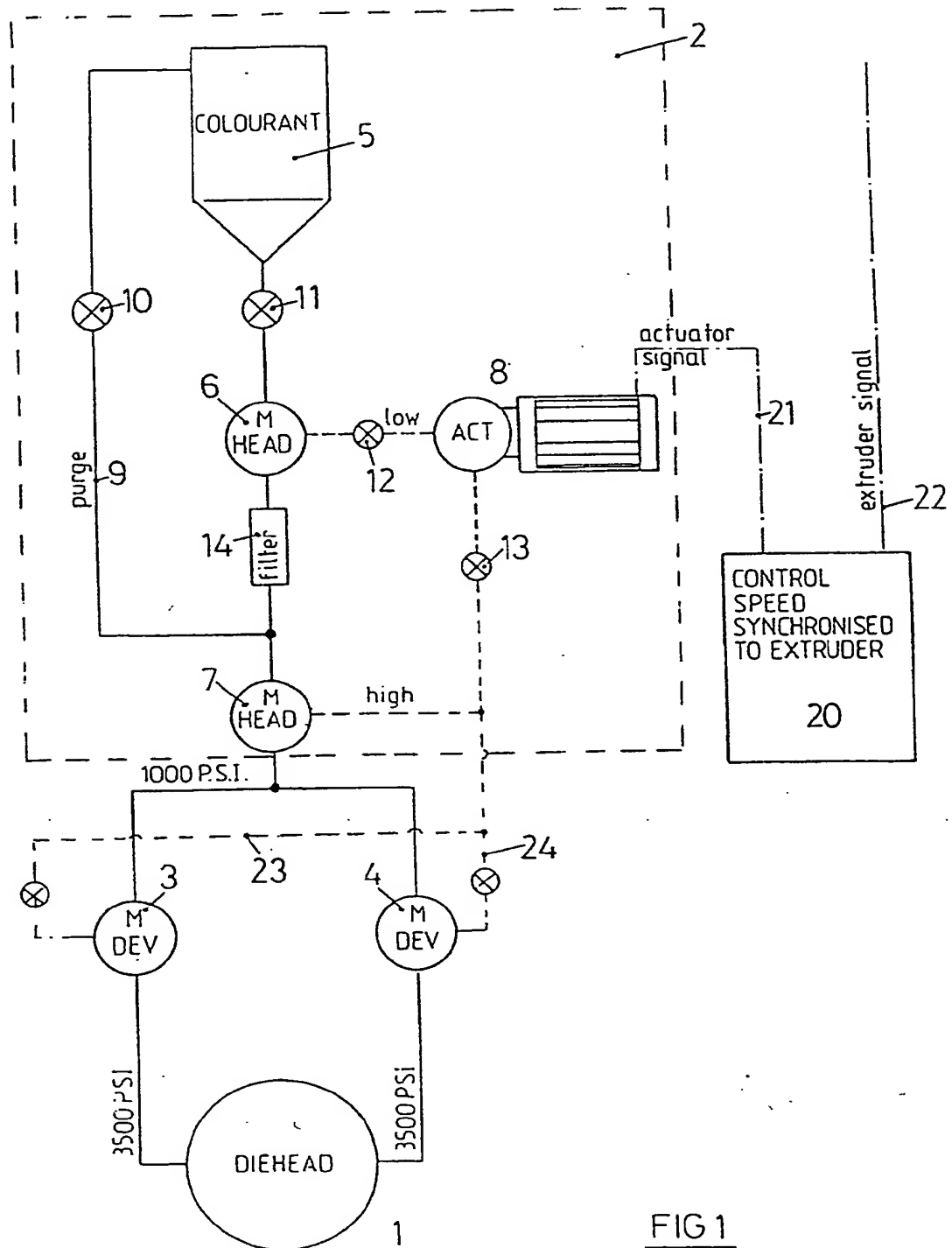
It will be appreciated that the above embodiments
10 have been described by way of example and that many
variations are possible without departing from the
scope of the invention. There may be only one
gearpump or more than two gearpumps supplying a
corresponding number of stripes. The or each gearpump
15 could be designed to supply more than one colourant
outlet and therefore produce more than one stripe.
Individual colourant supplies can be provided for
different pumps thereby enabling stripes of differing
colour to be produced. The width disposition,
20 orientation may be varied as desired. The width of a
single stripe may be such as to extend completely around
the extruded material to provide a skin coating. Stripes
may be made continuous or discontinuous.

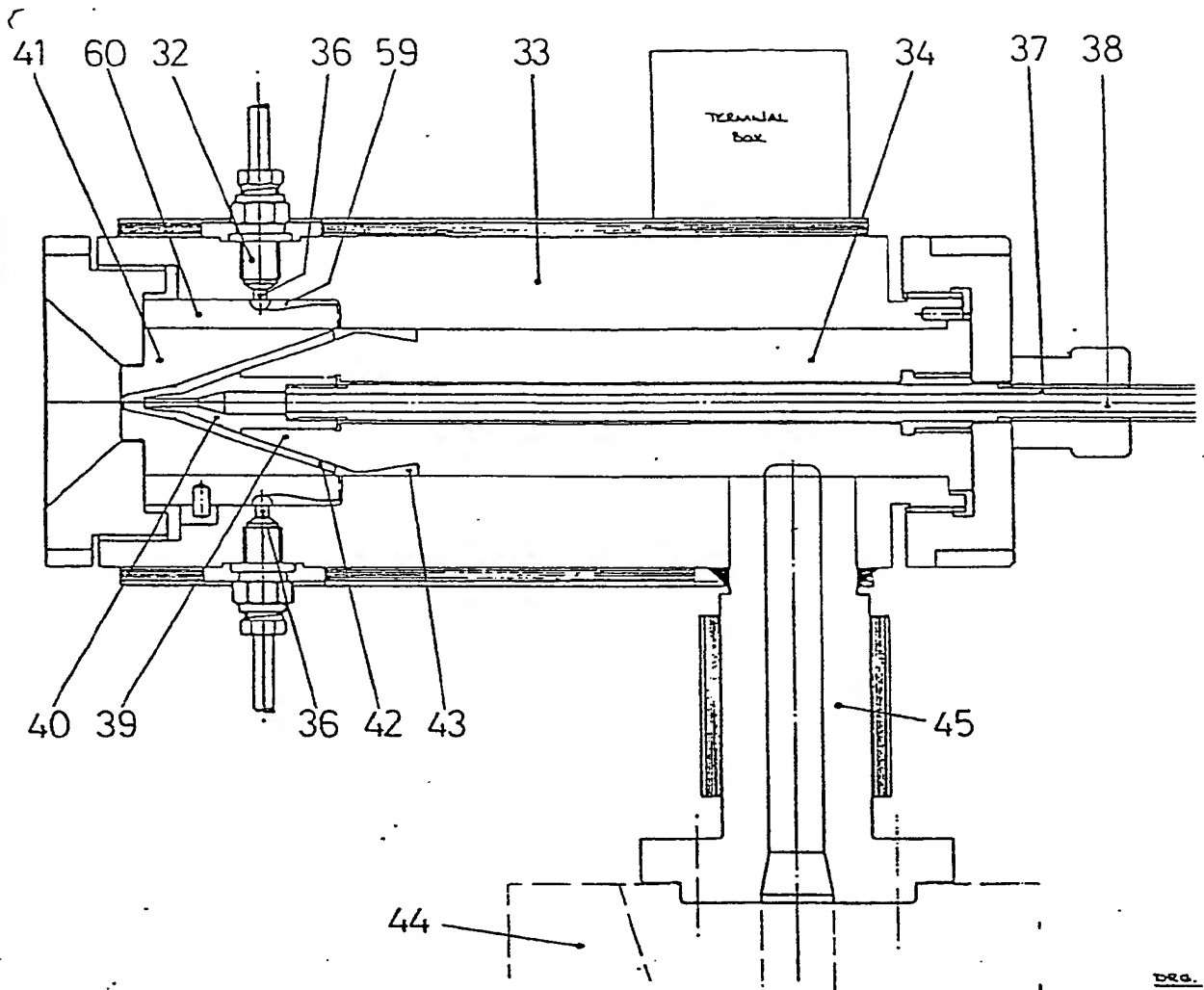
CLAIMS

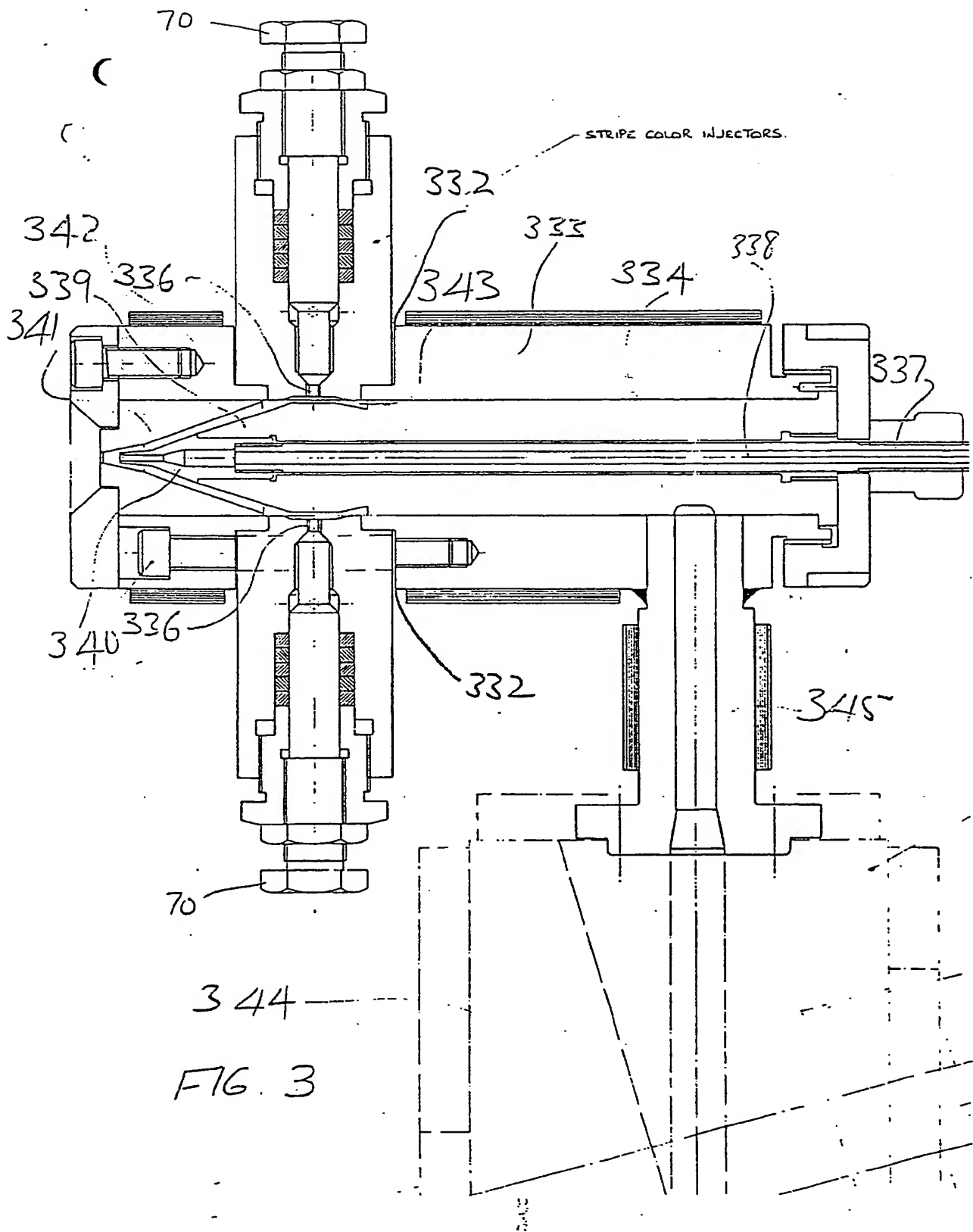
1. Apparatus for modifying an extruded material comprising a diehead (1), an extruder (44) for supplying extruded material to the diehead (1), and a metering device (3, 4) for feeding additive to the extruded material to modify the extruded material.
2. Apparatus as claimed in claim 1, in which the metering device (3, 4) is disposed to feed additive to the extruded material at the diehead (1).
3. Apparatus as claimed in claim 1, in which the metering device (63, 64) is disposed to feed additive to the extruded material between the extruder (644) and the diehead (61).
4. Apparatus as claimed in claim 1, in which a plurality of metering devices (3, 4) are provided to supply additive at respective points to the extruded material.
5. Apparatus as claimed in claim 4, in which the respective points are at the diehead (1).
6. Apparatus as claimed in claim 4, in which the respective points are between the extruder (644) and the diehead (61).

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7. Apparatus as claimed in any preceding claim in which the metering device is a reciprocating piston pump, a diaphragm pump or a gear pump.
- 5 8. Apparatus as claimed in any preceding claim in which at least one further metering device (6) is provided to boost the pressure in the additive feed line.
- 10 9. A method of modifying an extruded material including the steps of supplying an extruded material to a diehead (1) and feeding and metering additive to the extruded material to modify the extruded material.
- 15 10. A method as claimed in claim 9 in which the additive is a colourant.

TRIPE APPLICATION AT DIEHEAD





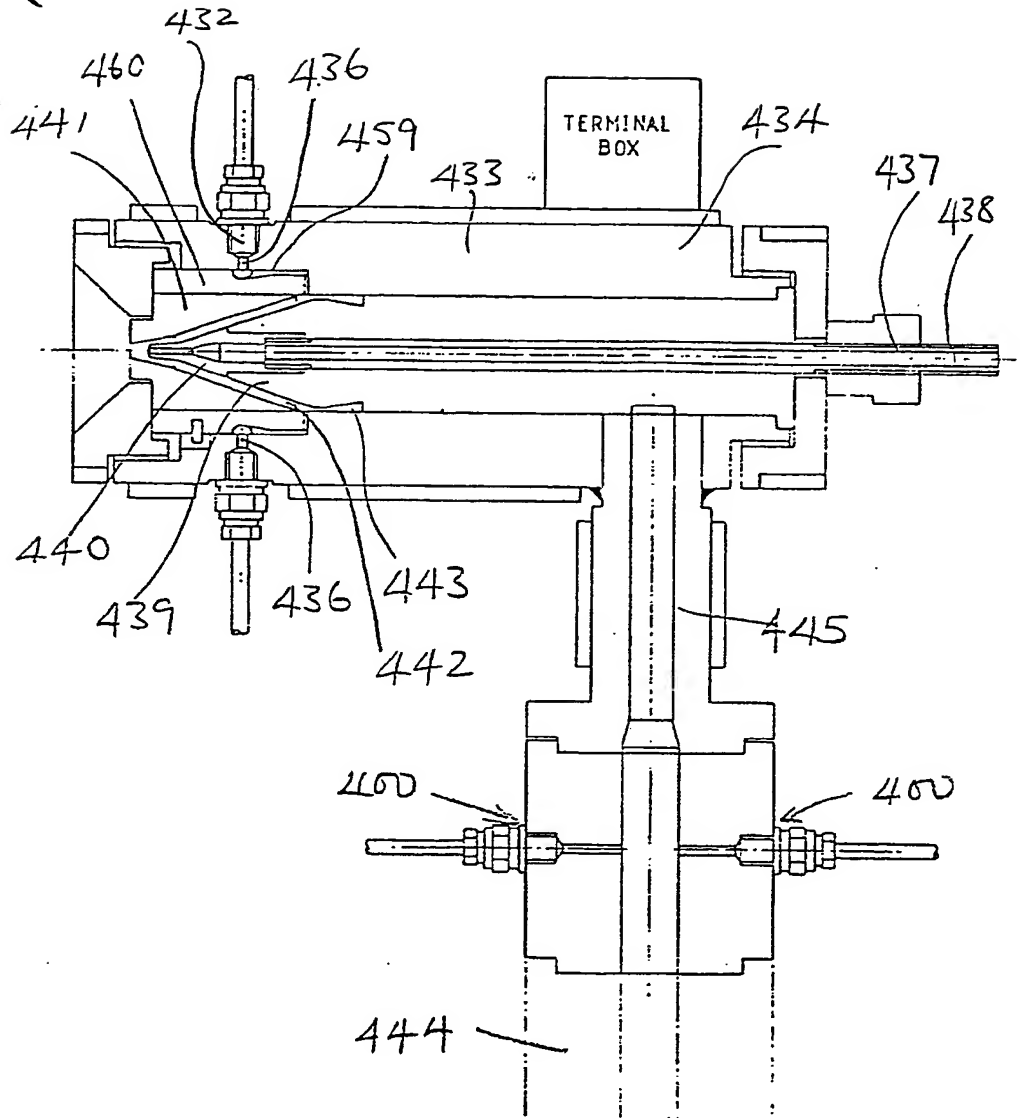


FIG. 4

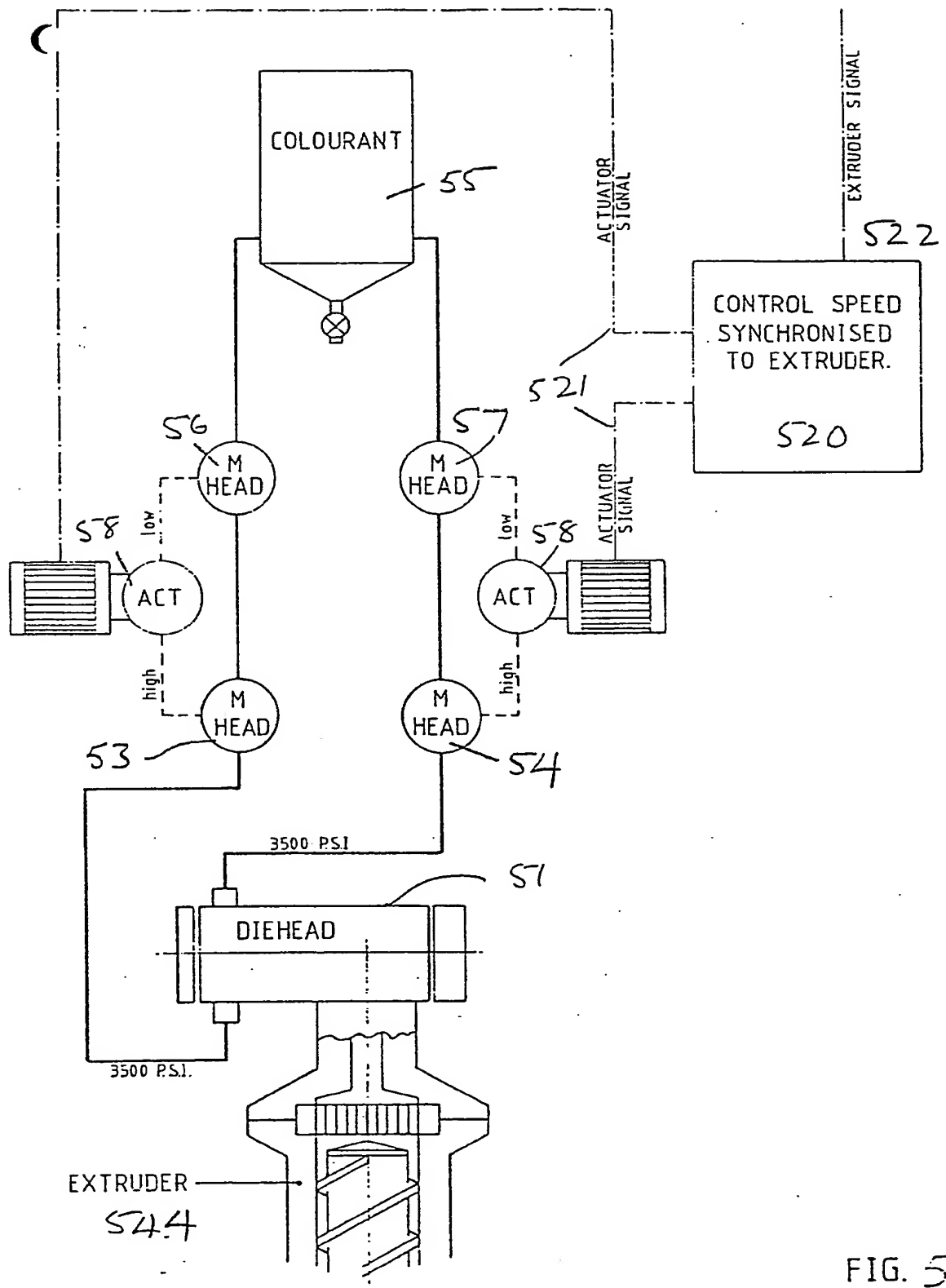


FIG. 5

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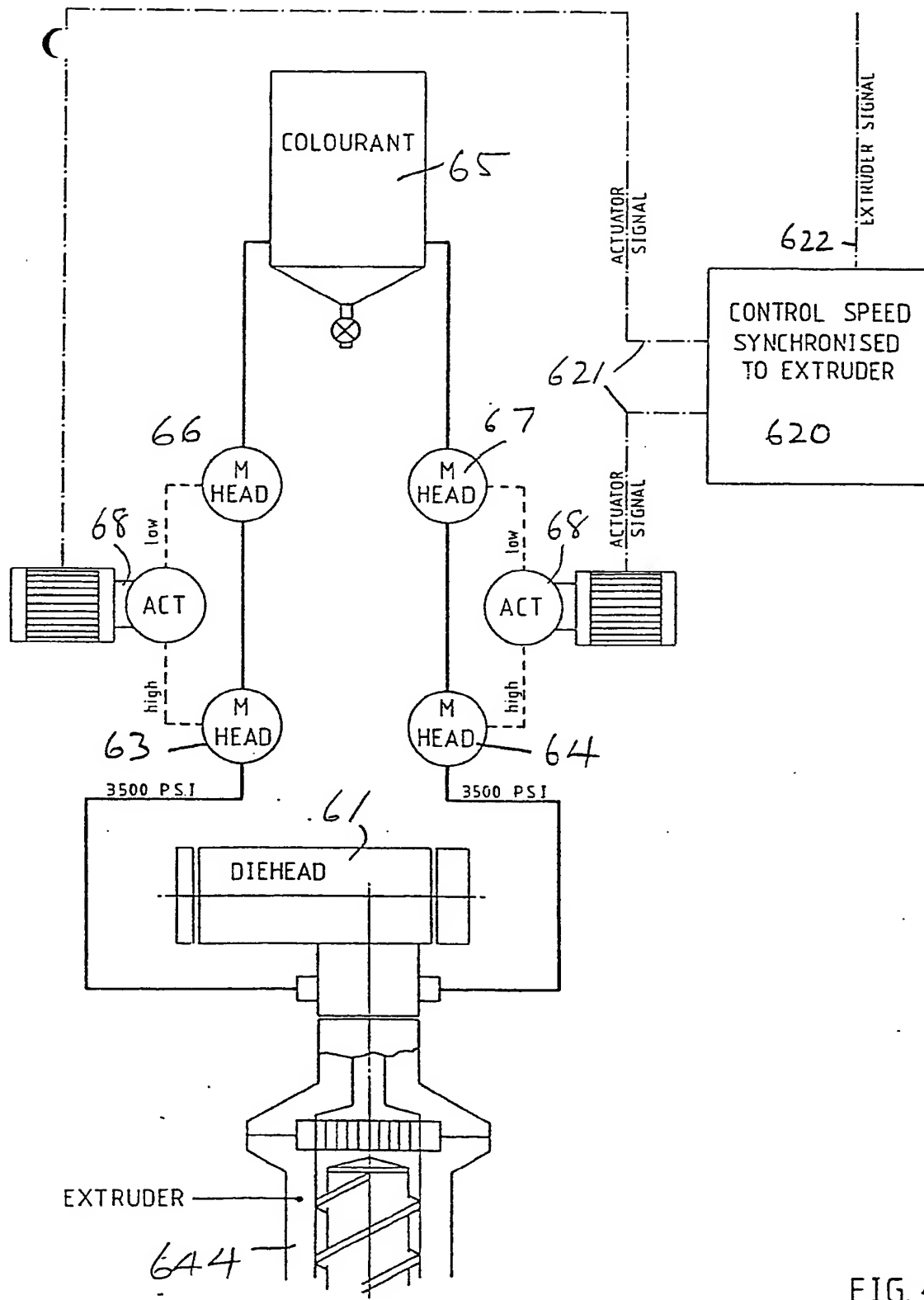


FIG. 6

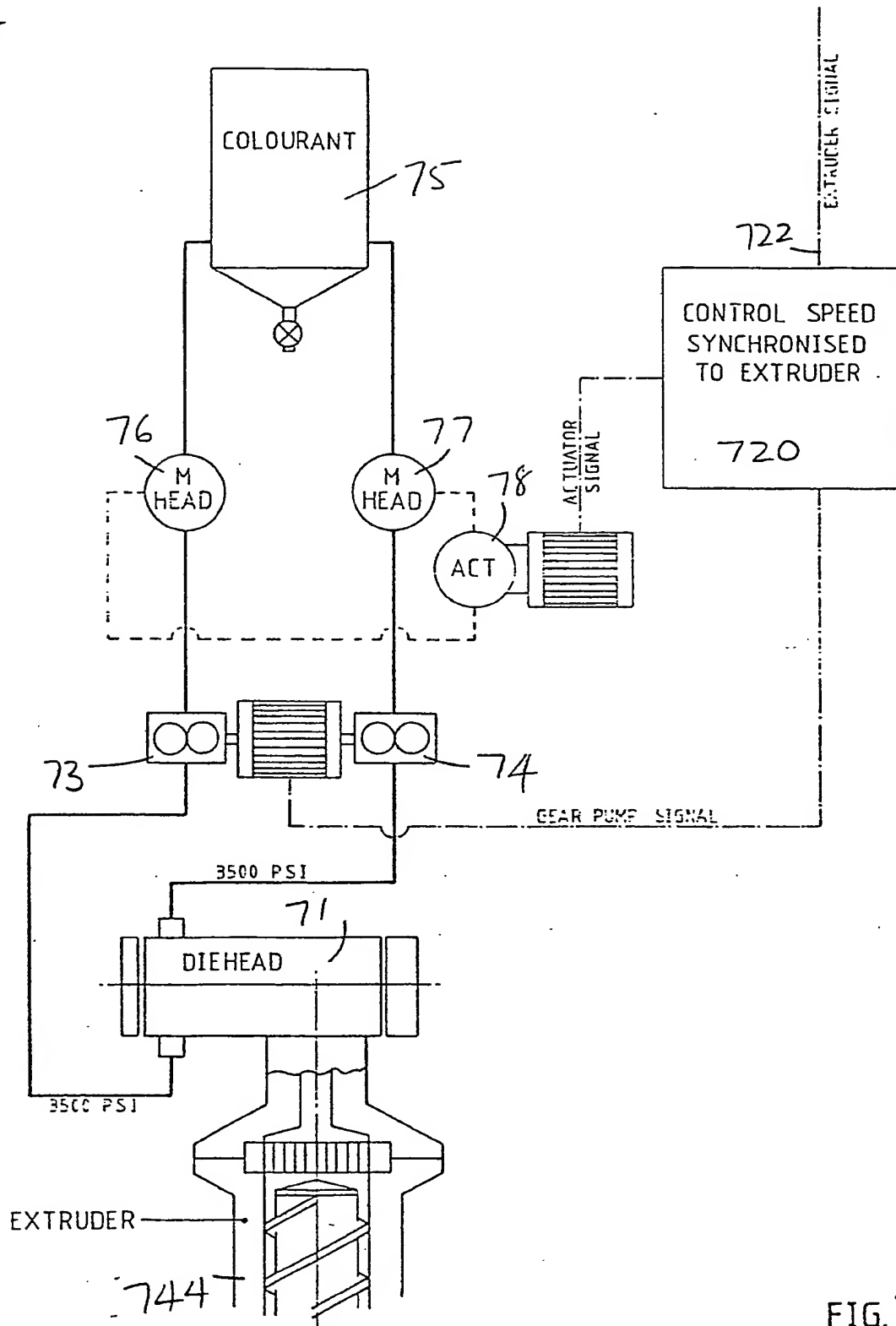


FIG. 7

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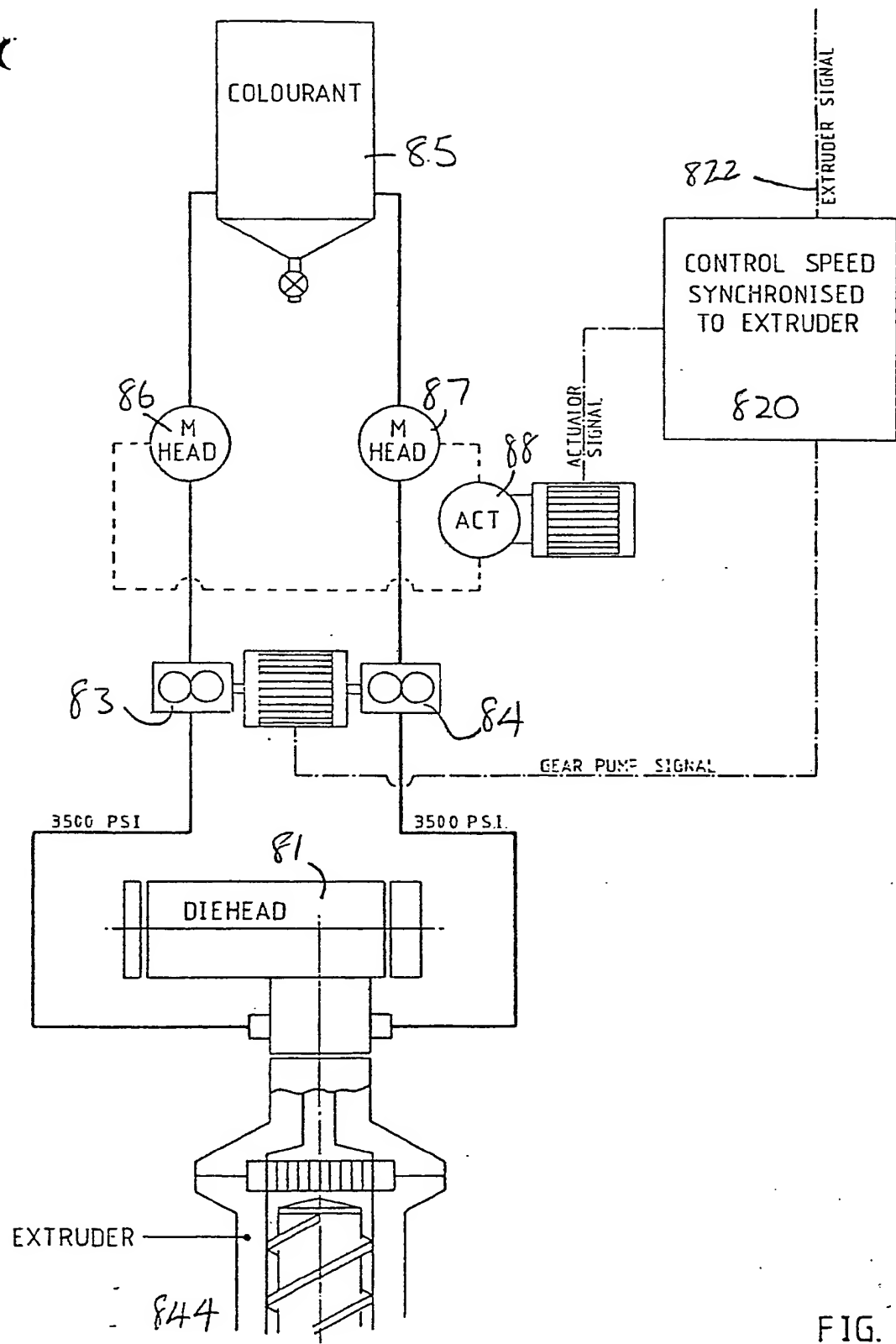


FIG. 8

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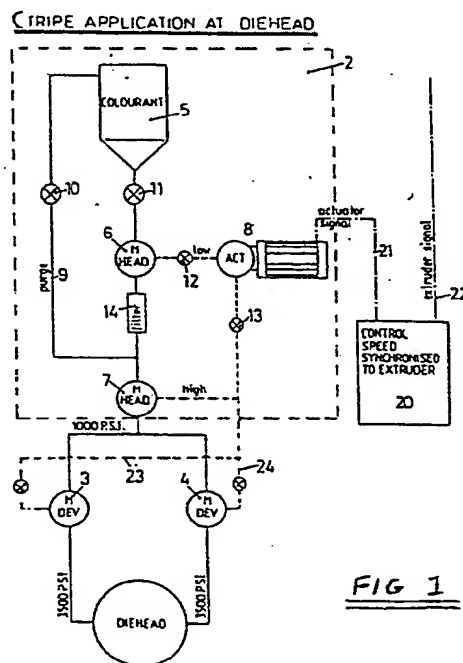


FIG 1



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EUROPEAN SEARCH REPORT

0161857
Application number

EP 85 30 3013

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
X	US-A-4 182 601 (HILL) * Figure 2; column 3, lines 40-50 *	1, 2, 4, 5, 7-10	B 29 C 47/04 B 29 C 47/10 B 29 C 47/28 B 29 C 47/92
Y		6	
X	DE-B-1 080 646 (SIEMENS-SCHUKERTWERKE) * Figures *	1, 2, 4, 5, 9, 10	
Y		6, 8	
X	GB-A- 401 529 (THE LIVERPOOL ELECTRIC CABLE CO. LTD.) * Figures 1, 6 *	1, 2, 4, 5, 9, 10	
Y		6, 8	TECHNICAL FIELDS SEARCHED (Int. Cl. 4) B 29 C
X	LU-A- 30 831 (MAPRE MACHINES ET APPAREILS DE PRECISION) * Figure 2 *	1, 2, 4, 5, 9	
Y		6, 8	
X	US-A-4 248 824 (HATTOP) * Figure 1 *	1, 2, 9, 10	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 20-10-1986	Examiner ASHLEY G.W.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	





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EUROPEAN SEARCH REPORT

0161857

Application number

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DOCUMENTS CONSIDERED TO BE RELEVANT			Page 2
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
Y	---	6, 8	
X	US-A-4 285 648 (JOCTEUR) * Figure 2 *	1, 3, 9	
Y	---	6, 8	
Y	EP-A-0 010 743 (KABEL UND LACKDRAHTFABRIKEN) * Figure 1; claim 1; page 1, line 5 *	8	
A	GB-A-2 059 864 (OY NOKIA AB) * Page 1, lines 10, 81-83; page 2, line 37; figures 2, 3 *	1, 3, 4, 6, 7, 9, 10	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 20-10-1986	Examiner ASHLEY G.W.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone		T : theory or principle underlying the invention	
Y : particularly relevant if combined with another document of the same category		E : earlier patent document, but published on, or after the filing date	
A : technological background		D : document cited in the application	
O : non-written disclosure		L : document cited for other reasons	
P : intermediate document		& : member of the same patent family, corresponding document	

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